

163168

163168

Page 1

Thursday, June 22, 2017 10:17:31 AM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: JUN 22 2017 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750-041

G

DAS
6
9-89

AUG 10 2017

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

record fwd angle: 89.9

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

DAS
28
9-89

AUG 11 2017

B163168LH

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Item ID: D350-636-011

Accept

N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

110

Skidtubes

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16",
then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN
first side. Repeat process on second side.***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP
WHEN DRILLING FIRST SIDE***Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig
DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B)4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade
fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND
ANGLE.6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

8-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004DAS
6
9-89

AUG 10 2017

0.82

2017/07/03 AP



BB 170703

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Item ID: D350-636-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.
Start Date: 6/22/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/5/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	A/R Aluminum Rod batch: <u>M36920</u>								
	9-Grind welds flush as per Dwg D2750								
120	QC10- Inspect visual per QSI004- ground welds	0.00							
120									
QC	Memo	0.00							
Quality Control									
									DAS 38 9-89 JUL 04 2017
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.02							
Quality Control									
									DAS 38 9-89 JUL 04 2017

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 6/22/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00 * 1 *

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

Accept Qty

Reject
QtyReject
Number

**Insp.
Stamp**

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

Memo

0.70

HandFinish

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

150

Memo

0.01

QC

Quality Control

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Item ID: D350-636-011

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

160

Skidtubes

Skidtubes

Memo

1.08

1-Open up holes using hole saw of Detail C and ground handling to 0.625"
(total of 8 holes per side)
as per dwg D2750.

2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole using un-bit to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291

batch: M 137127exp. date: 17-09-26

ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod

batch: M137133

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

17-07-06

DJ

BB 17-07-11

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Item ID: D350-636-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.
Start Date: 6/22/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/5/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750								
	12-Deburr holes, ensure tube is free of all scratches before sending to paint.								
170	QC10- Inspect visual per QSI004- ground welds	0.00				1			
170									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 JUL 21 2017
180	QC5- Inspect part completeness to step on W/O	0.00				1			
180									
QC	Memo	0.02							
Quality Control	***VERIFY C'BOARD IS GOOD***								DAS 38 9-89 JUL 21 2017

2017/07/17 AP
JH

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Item ID: D350-636-011

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N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.44				①	1		2017-07-31 JSL
200 *200* SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>137195</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>138058</u>	0.00 0.34				1			DAS 41 9-89 AUG 02 2017
210 *210* QC Quality Control	QC14- Inspect Spray Paint Memo Inspect for foreign object per QSI 024	0.00 0.00				164	d	17/08/10	DAS 15 9-89

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Item ID: D350-636-011

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Setup Start

NS1

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NS2

Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Assemble as per dwg HandFinishing	0.00							
230 HandFinish	Memo	1.32							
Hand Finishing	1- Install inserts as per Dwg D2750								
	2-Inspect for Foreign Objects								
	3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M137546</u> EXP DATE: <u>18103</u>								
	4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M135475</u>								
	5- Coat all exposed fasteners with "LPS Procyon" batch: <u>M133640</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240 QC	Memo	0.02							
Quality Control									

DAS
38
7-89

AUG 10 2017

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Item ID: D350-636-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.01							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.03							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								
270	Identify as per dwg & Stock Location: _____	0.00							
270									
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011 Location : FG072								

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Item ID: D350-636-011

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.10

Quality Control

DAS
21
9-89

AUG 11 2017

DAS
21
9-89

AUG 11 2017

Picklist Print

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Page 1

13

Work Order ID: 163168

163168

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
IPP Rev:J 06-03-23 As per Rev D JLM
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
DD verf:EC IPP Rev:P 10.06.22 revise
seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
DD verf:EC IPP REV:R 13.08.27 PER ECN13-594 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	144.0000	8	8			
D3492-1									**			lll 17/08/04	
Plug													

Location	Loc Qty	Loc Code
FP001	144	
158389	1	
159298	63	
161306	80	

D3492-3		Manufactured	No			230	Each	218.0000	8	8			
D3492-3									**			lll 17/08/04	
Plug													

Location	Loc Qty	Loc Code
FP001	218	
159296	136	
162347	82	

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Work Order ID: 163168

163168

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

203.0000

8

8

NAS1611-010

O-RING

**

all 12/08/01

Location

Loc Qty

Loc Code

FP001

203

11137963

x0

m134955

7

m135603

8

m136182

4

m136836

84

m137587

100

NAS1149D0863J

Purchased

No

250

Each

264.0000

2

2

NAS1149D0863.J

Washer

**

AUG 10 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

46

125484

46

ST260a

100

125635

100

ST263

118

125268

118

2

D2744

Manufactured

No

110

Each

20.0000

1

1

D2744

Cap

**

861707-03

Location

Loc Qty

Loc Code

LG001

20

159371

10

161732

10

1

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT-LH

Manufactured No

110

Each

3.0000

1

1

D2600-3-BENT-LH

Extrusion Bent LH

**

Location

Loc Qty

Loc Code

LG002

3

158771

3

161684

160

Each

172.0000

8

8

D2743

Manufactured No

D2743

Crossbolt Spacer

**

Location

Loc Qty

Loc Code

LG001

172

159308

62

160400

110

8

D2739

Manufactured No

D2739

350 I Beam

**

Location

Loc Qty

Loc Code

LG002

11

159936

3

161380

8

161684

160

Each

83.0000

4

4

D3490-3

Manufactured No

D3490-3

Cross Bolt Spacer

**

Location

Loc Qty

Loc Code

LG001

83

160393

83

4

2017/07/03 (AP)

8E17-07-10

17-07-06 DC

8E17-07-10

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Parent Item: D350-636-011

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Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

95.0000

4

4

D3490-1

Cross Bolt Spacer

**

BETTER 10

Location

Loc Qty

Loc Code

LG001

95

160394

95

4

ALS4-1032-225

AELS8-1032-225

Purchased

No

160

Each

2,629.000

38

38

ALS4-1032-225

Rivnut

**

all 12/08/01

Location

Loc Qty

Loc Code

FG

25

M134975

20

M135998

5

FP001

2204

M135603

40

M135920

38

M135998

2115

M136265

11

x38

ST556

400

M136579

400

D3793-3

Manufactured

No

230

Each

29.0000

1

1

D3793-3

Wearplate Aft

**

all 12/08/01

Location

Loc Qty

Loc Code

FP002

29

159397

4

159871

25

X1

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D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

124.0000

1

1

AN8C35A

Bolt

**

all 12/08/02

Location

Loc Qty

Loc Code

FG

3

121275

3

FP001

121

m133336

1

m134130

1

m134133

7

m137203

112

XL

D3793-1

Manufactured

No

230

Each

26.0000

1

1

D3793-1

Wearplate Fwd

**

all 12/08/02

Location

Loc Qty

Loc Code

FP002

26

159358

4

159874

22

XL

D3488-041

Manufactured

No

230

Each

2.0000

1

1

D3488-041

Blade Fitting LH

**

all 12/08/02

Location

Loc Qty

Loc Code

FP001

2

B162409

158789

2

XL

D3794-3

Manufactured

No

230

Each

13.0000

1

1

D3794-3

Gasket Aft

**

all 12/08/02

Location

Loc Qty

Loc Code

FP001

13

B163320

159369

12

159924

1

XL

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Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

376.0000

4

4

AN6C44A

Bolt

**

all 12/08/02

Location

Loc Qty

Loc Code

FP001

78

m132556

78

x4

over009

250

m137055

250

ST333

48

m136658

48

MS21083C8

Purchased

No

230

Each

63.0000

1

1

MS21083C8

Nut

**

all 12/08/02

Location

Loc Qty

Loc Code

FP001

18

m137412

18

x1

ST297

45

m137361

25

m137820

20

D3536-25

Manufactured

No

230

Each

27.0000

1

1

D3536-25

Gasket Center

**

all 12/08/02

Location

Loc Qty

Loc Code

FG

3

95328

3

FP001

24

146747

2

159368

4

162506

18

x4

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Parent Item: D350-636-011

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Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No 230 Each 159.0000 8 8

D3631-1

Washer

**

all 12/08/04

Location

Loc Qty

Loc Code

FP001

159

159502

59

160124

100

x8

D3791-1

Manufactured No

230 Each

20.0000

1

1

D3791-1

Wearpad

**

all 12/08/04

Location

Loc Qty

Loc Code

FP002

20

158753

10

161928

10

x1

NAS1149C0332R

Purchased No

230 Each

4,974.000

38

38

NAS1149C0332R

WASHER

**

all 12/08/04

Location

Loc Qty

Loc Code

FP001

1470

m137597

1470

GA

508

m133284

22

m136444

486

ST260a

2000

m135408

0

m136741

0

m137851

2000

ST266

996

m137381

996

M1137951

x38

Picklist Print

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Page 8

Work Order ID: 163168

163168

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

182.0000

8

8

D2745

Bushing

**

all 12/08/04

Location

Loc Qty

Loc Code

FP001

182

B163474

x6

159297

82

x2

161760

100

AN3C5A

Purchased No

230

Each

928.0000

34

34

AN3C5A

Bolt

**

all 12/08/04

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

657

M137361

657

x34

OVER002

200

M137710

200

ST350

66

M135442

66

Picklist Print

Thursday, June 22, 2017 10:17:35 AM

Page 9

Work Order ID: 163168

163168

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

162.0000

3

3

D3537-1

Wearpad

**

all 12/08/04

Location

Loc Qty

Loc Code

FG

11

B163518

x3

79833

1

88562

10

FP001

151

141922

7

147593

5

154226

1

159356

38

161530

50

161531

50

NAS1149C0832R

Purchased

No

230

Each

49.0000

1

1

NAS1149C0832R

Washer

**

all 12/08/04

Location

Loc Qty

Loc Code

FP001

49

m135536

49

x1

Picklist Print

Thursday, June 22, 2017 10:17:35 AM

Page 10

Work Order ID: 163168

163168

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

147.0000

4

4

AN3C6A

Bolt

**

all in stock

Location

Loc Qty

Loc Code

FG

10

M138040

x4

122416

10

FP001

21

m136295

4

m136781

17

OVER002

96

m137361

96

ST350

20

m128704

18

m132767

2

NAS1611-013

Purchased

No

230

Each

174.0000

8

8

NAS1611-013

O-Ring

**

all in stock

Location

Loc Qty

Loc Code

FP001

174

m137333

174

x8

D3535-25

Manufactured

No

230

Each

18.0000

1

1

D3535-25

Wearplate Center

**

all in stock

Location

Loc Qty

Loc Code

FG

1

148669

1

FP002

17

159879

7

161915

10

x1

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Shop Packet Print

Page 10

Picklist Print

Thursday, June 22, 2017 10:17:35 AM

Page 11

Work Order ID: 163168

163168

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

15.0000

1

1

D3794-1

**

Gasket Fwd

all 12/08/06

Location

Loc Qty

Loc Code

FP001

15

142770

1

150417

2

159376

12

xl

MS21043-6

Purchased No

230

Each

72.0000

4

4

MS21043-6

**

NUT

all 12/08/06

Location

Loc Qty

Loc Code

FG

20

103693

20

11137963

x4

FP001

12

m135470

2

m137361

10

ST302

40

m137479

40

D3493-1

Manufactured No

250

Each

39.0000

2

2

D3493-1

**

Washer

AUG 10 2017 *DAS 6 27*
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST037

29

159305

9

161754

20

163460

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

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Page 11

Picklist Print

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Page 12

Work Order ID: 163168

163168

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

63.0000

2

2

MS21083C8

Nut

**

AUG 10 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

18

m137412

18

ST297

45

m137361

25

m137820

20

AN8C21A

Purchased

No

250

Each

302.0000

2

2

AN8C21A

Bolt

**

AUG 10 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

4

123966

2

m132169

2

over004

217

m137162

217

ST332

81

m136262

1

m137162

80

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Page 12

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Work Order ID: 163168

163168

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

403.0000

4

4

***NAS1515H3I ***

Washer

**

all 120808

Location	Loc Qty	Loc Code
----------	---------	----------

FG	40	
102472	40	
FP001	359	
m127831	20	
m134508	3	
m135600	2	
m136263	4	
m137361	330	
ST266	4	<i>xd</i>
m130726	4	

D2741

Manufactured

No

250

Each

47.0000

1

1

D2741

Replacement Blade

**

**DAS
28
9-89**

Location	Loc Qty	Loc Code
----------	---------	----------

FG	10	
131616	10	
ST538	37	
132981	14	
158915	23	

**DAS
27
9-89**
AUG 1 0 2017

D3532-1

Manufactured

No

250

Each

45.0000

2

2

D3532-1

Spacer

**

**DAS
28
9-89**

Location	Loc Qty	Loc Code
----------	---------	----------

ST038	45	
159312	45	

**DAS
27
9-89**
AUG 1 0 2017

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1			D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE
WORK ORDER
NO. 163168 HCS
1206-22

RELEASED
2013-08-13
WD

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5-6-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 8413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN AG-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DCO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN9-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

REV. G

SHEET 1 OF 11

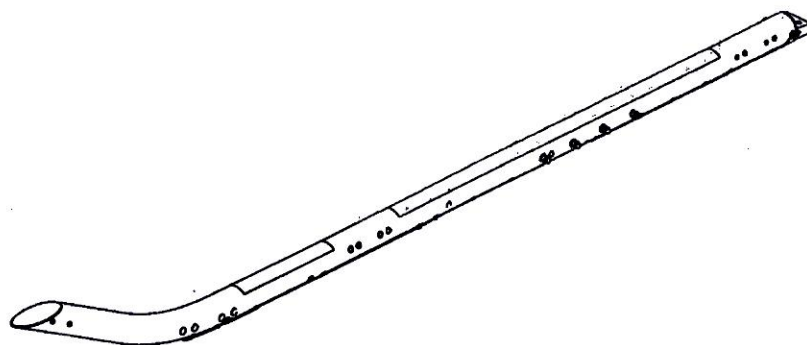
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350 SKIDTUBE ASSEMBLY

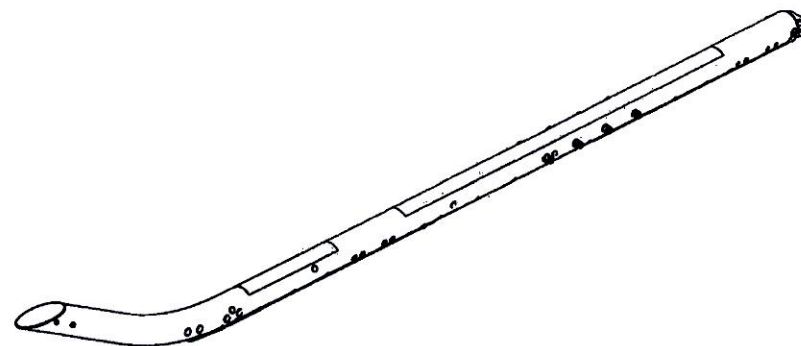
SCALE

NTS

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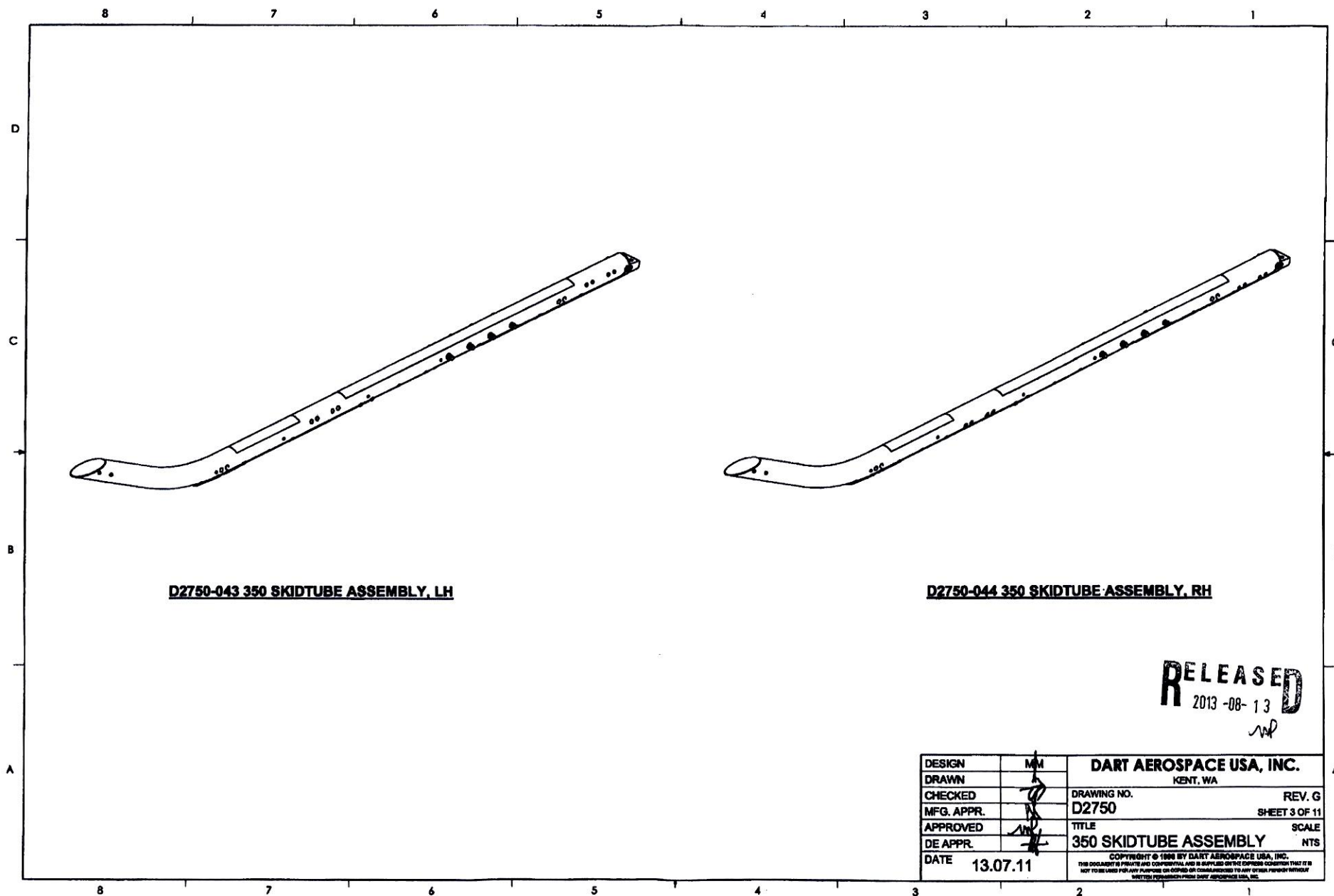
D2750-041 350 SKIDTUBE ASSEMBLY, LH



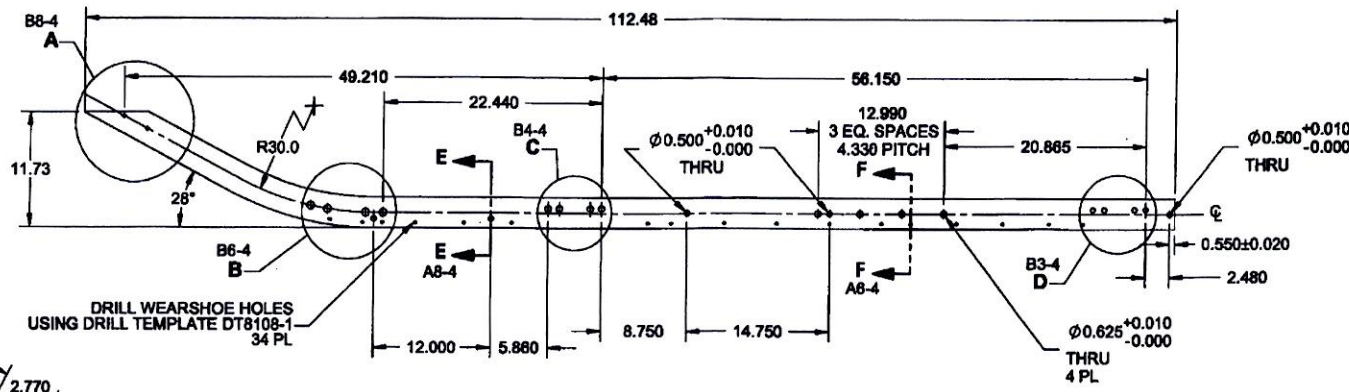
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
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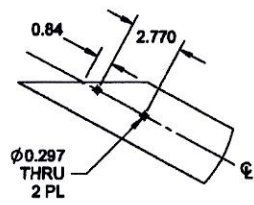
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MFG. APPR.		TITLE	SHEET 2 OF 11
APPROVED		350 SKIDTUBE ASSEMBLY	SCALE
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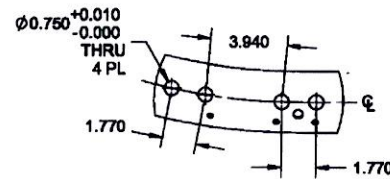
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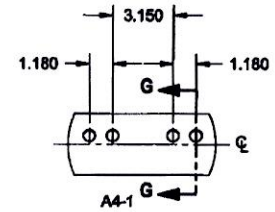
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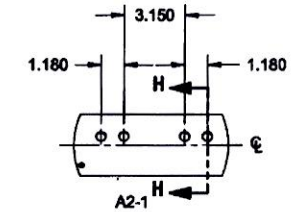
DETAIL A
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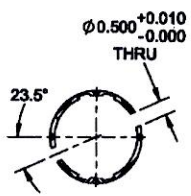
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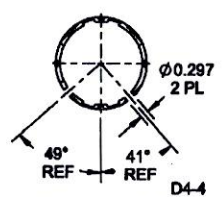
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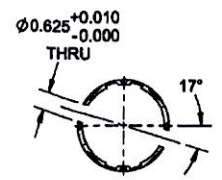
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SCALE 2X



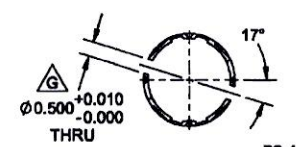
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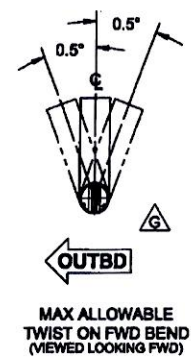
SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

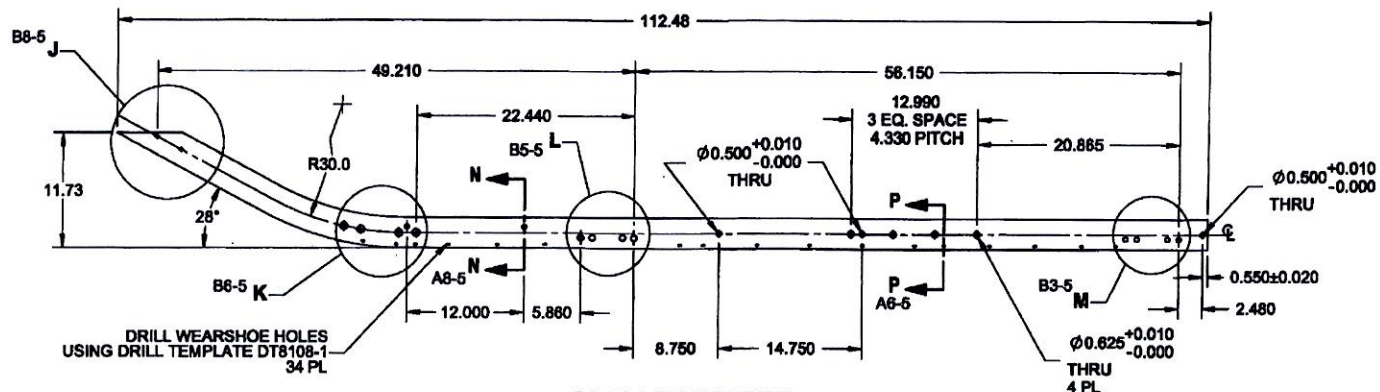


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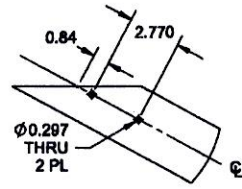
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8 7 6 5 4 3 2 1

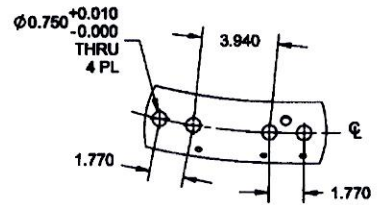
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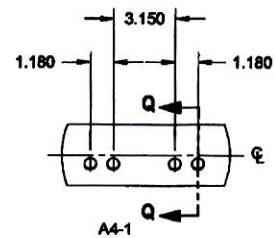
D2750-2 RH SKIDTUBE



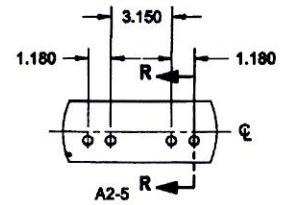
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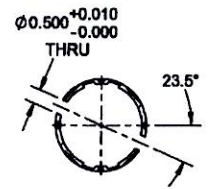
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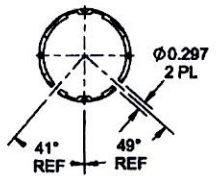
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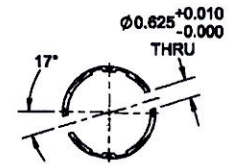
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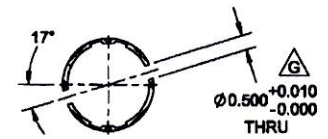
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SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

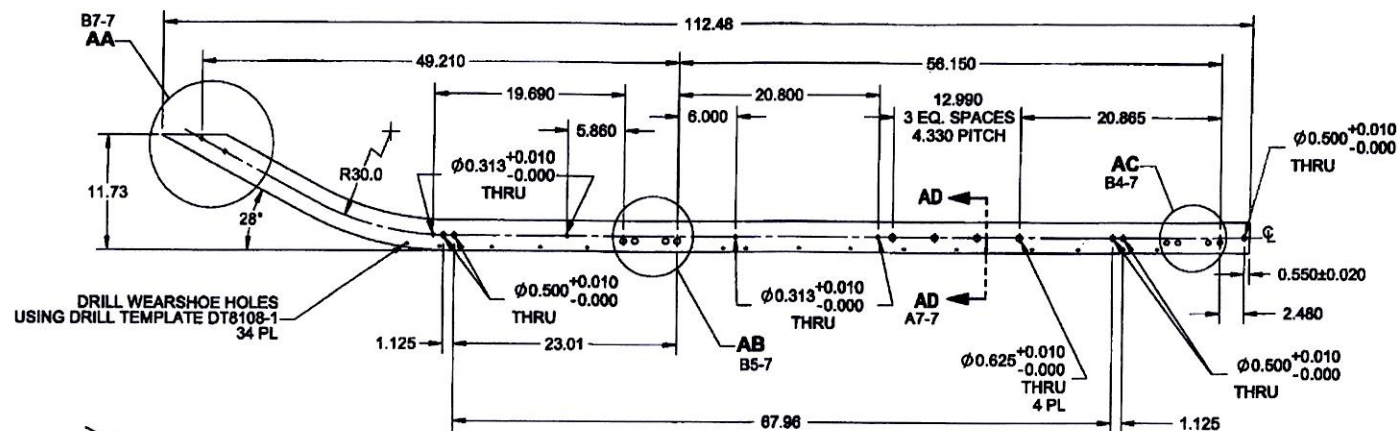
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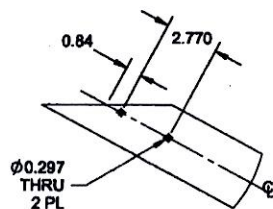


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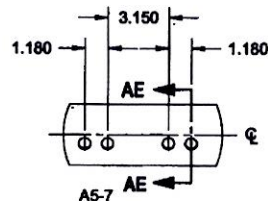
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DE APPR.		350 SKIDTUBE ASSEMBLY	NT
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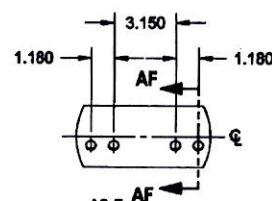
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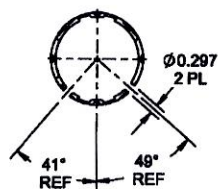
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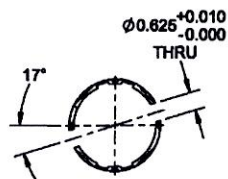
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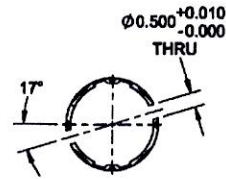
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SECTION AD-AD
SCALE 3X, 17 PL



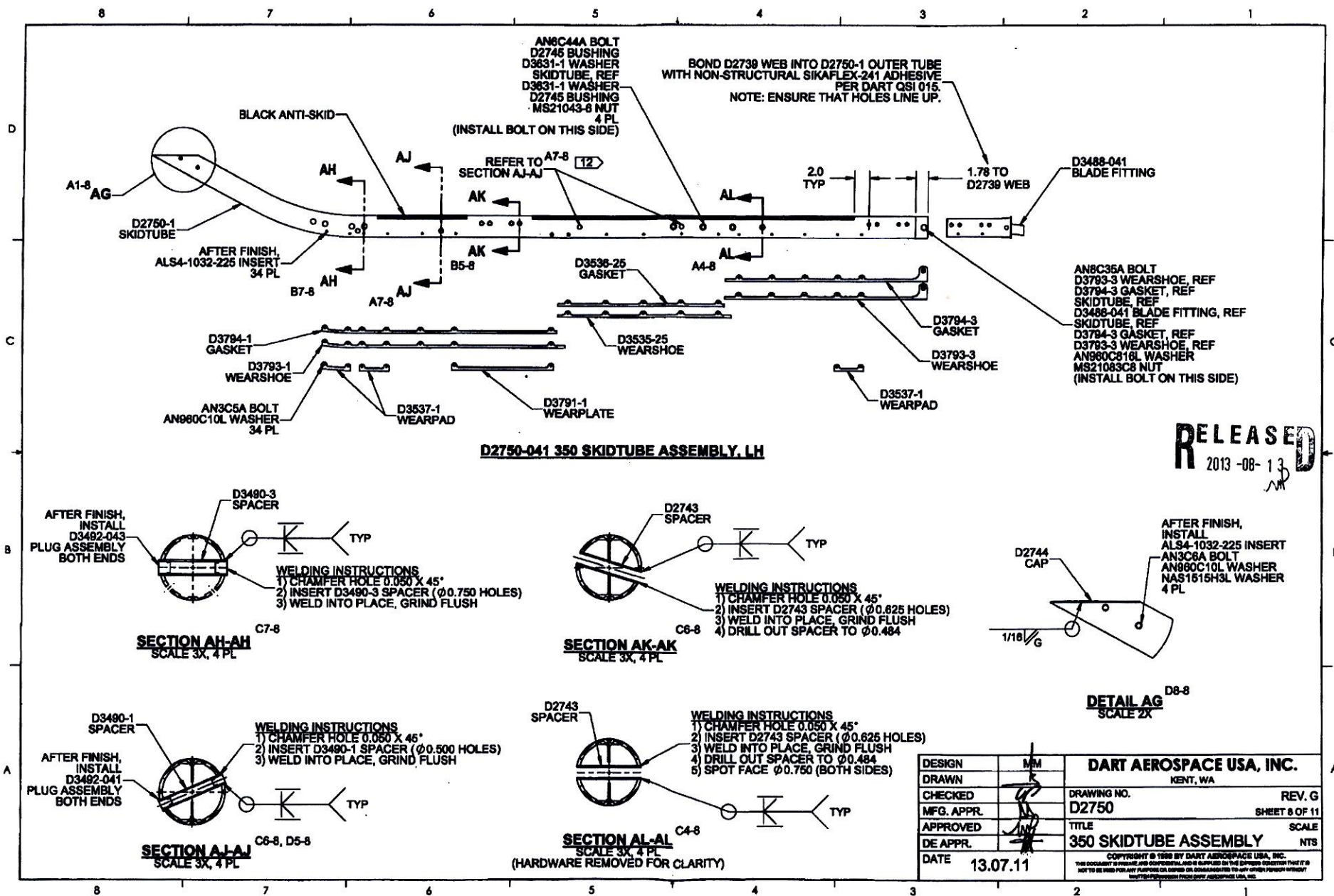
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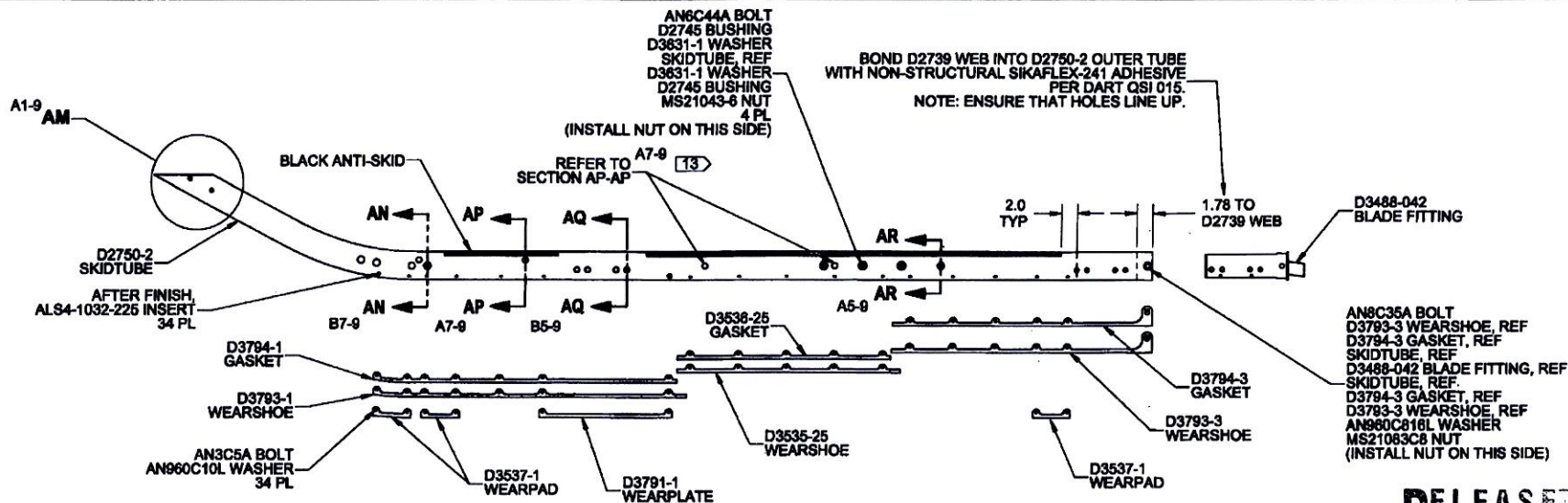
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 7 OF 11
APPROVED		TITLE	SCALE
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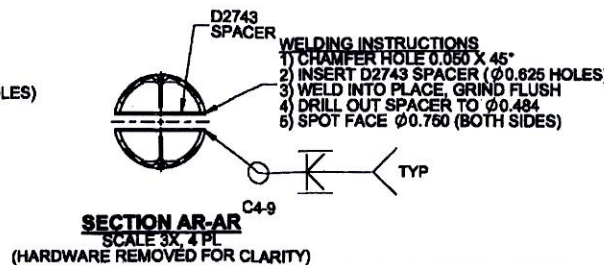
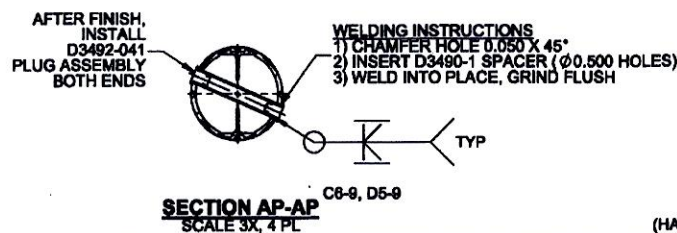
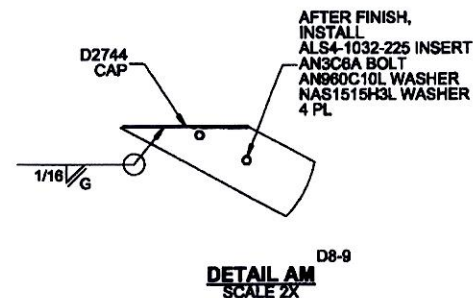
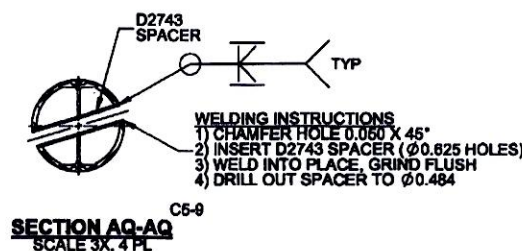
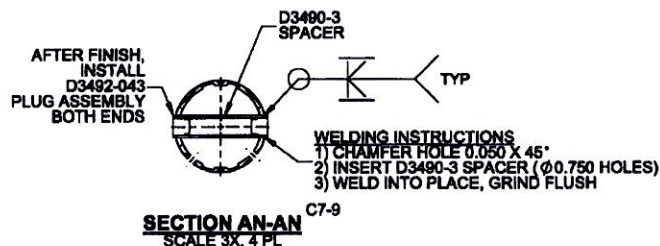
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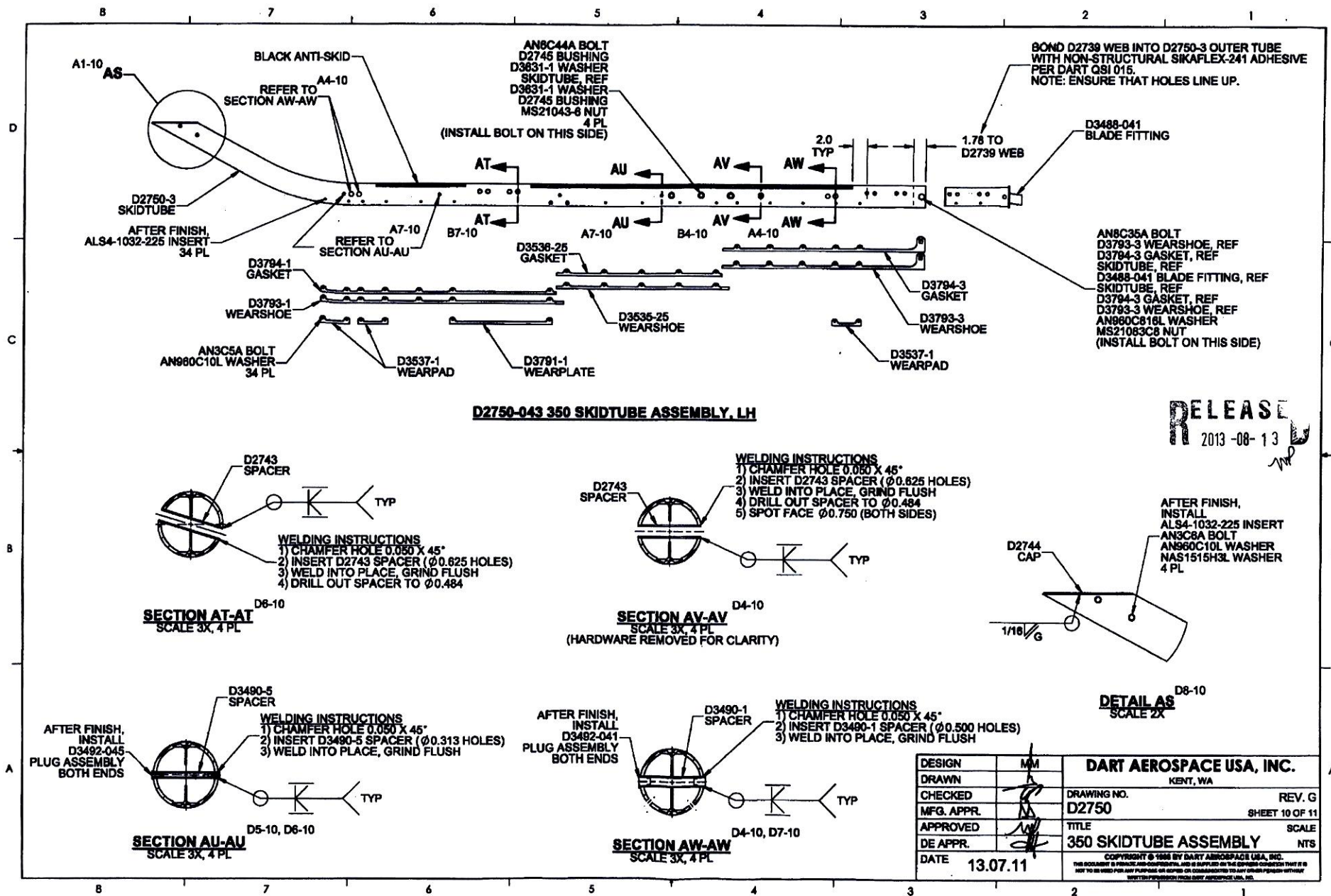
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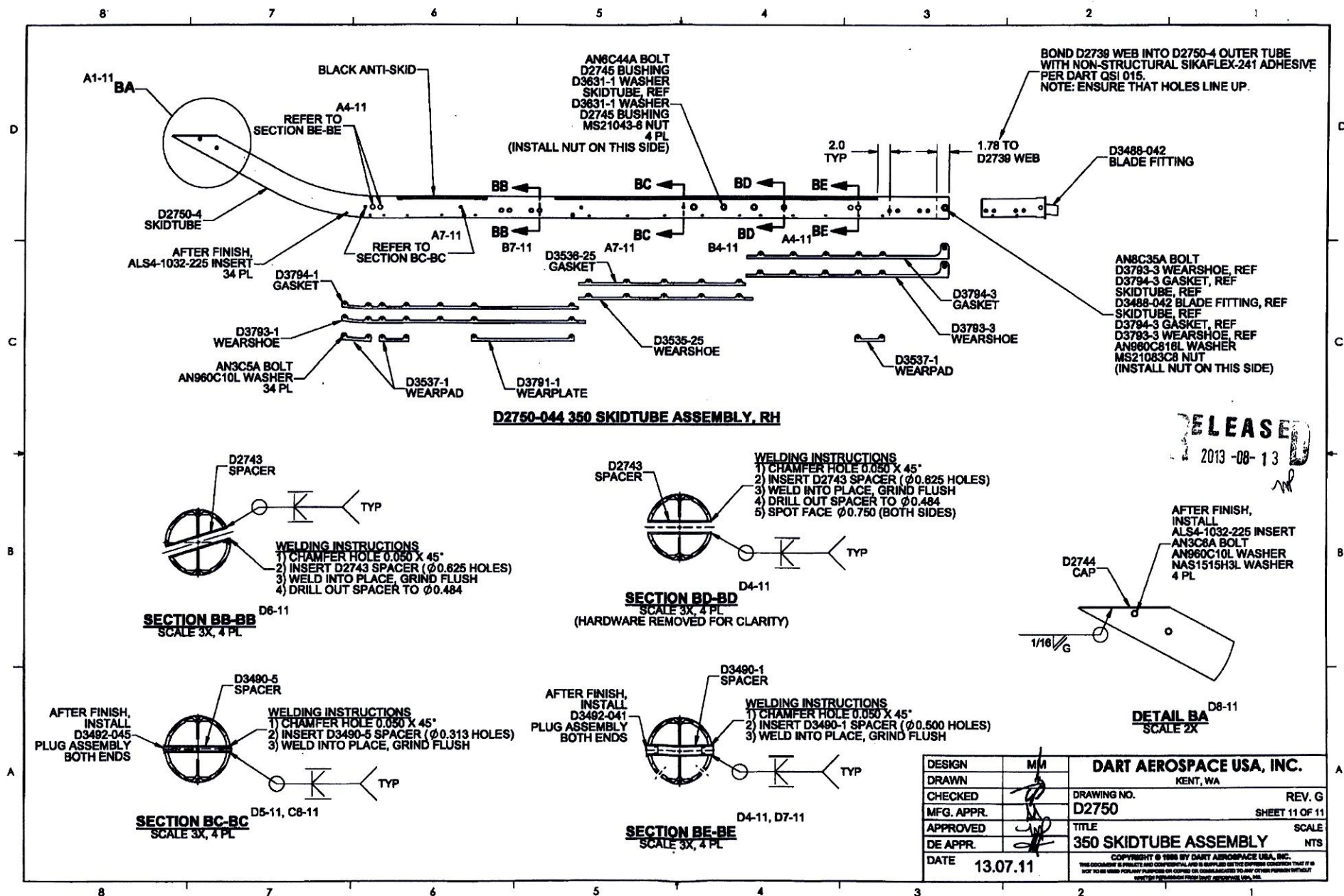
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Order ID 163168

163168

Page 1

Thursday, June 22, 2017 10:17:31 AM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:

Date: JUN 27 2017 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr Revision Nbr

D2750-041 G

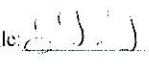
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record fwd angle: 

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

DAS
5
9-89

AUG 11 2017

United States of America
Department of Transportation - Federal Aviation Administration
Supplemental Type Certificate

Number SR00646SE

This certificate, issued to

**Dart Aerospace USA, Inc.
190 S. Danebo Ave.
Eugene, OR 97402**

*certifies that the change in the type design for the following product with the limitations and conditions therefore as specified hereon meets the airworthiness requirements of Part * of the * Regulations.*

Original Product—Type Certificate Number:

* See attached Federal Aviation Administration (FAA)

Make:

Approved Model List (AML) SR00646SE for approved

Model:

aircraft models and applicable airworthiness regulations

Description of the Type Design Change: Replacement of the original landing gear skid tubes with DART D350-636 skid tube system components as appropriate. The D350-636 skid tube system must be fabricated in accordance with DART Aerospace USA, Inc. Master Document List (MDL) No. MDL-D350-636, Revision N, dated September 01, 2010, or later Federal Aviation Administration (FAA) approved Revision. The skid tubes must be installed in accordance with DART Aerospace Installation Instructions No. INN-D350-636, Revision H, dated July 26, 2010, or later FAA accepted revision. This modification must be maintained in accordance with DART Aerospace Instructions for Continued Airworthiness (ICA) No. ICA-D350-636, Revision 1, or later FAA-approved revision.

Limitations and Conditions: Approval of this change in type design applies to rotorcraft listed on the Approved Model List (AML) only. This approve should not be extended to other rotorcraft of these models on which other previously approved modification are incorporated unless it is determined by the installer that the relationship between this change and any of those other previously approved modifications, including changes in type design, will introduce no adverse effect upon the airworthiness of the rotorcraft.

A copy of this Certificate, AML No. SR00646SE, and the ICA must be maintained as part of the permanent records for the modified rotorcraft.

If the holder agrees to permit another person to use this certificate to alter the product, the holder shall give the other person written evidence of that permission.

This certificate and the supporting data which is the basis for approval shall remain in effect until surrendered, suspended, revoked, or a termination date is otherwise established by the Administrator of the Federal Aviation Administration.

Date of application: April 24, 1998

Date reissued: October 28, 2015

Date of issuance: November 19, 1998

Date amended: September 27, 2010



By direction of the Administrator

[Signature]
(Signature)

[Title]
Manager, Seattle Aircraft Certification Office
(Title)

Any alteration of this certificate is punishable by a fine of not exceeding \$1,000, or imprisonment not exceeding 3 years, or both.

This certificate may be transferred in accordance with FAR 21.47.